

Process Sheet

CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET MOD KIT	
: 43930	Part Number	: DSI 9268011	
ate Number : 11337	Drawing Number	: D3230 REV B	
P.O. Number :	Project Number	: N/A	
This Issue : 05/12/2008 S.O. No. :	Drawing Revision	: B	
Prsht Rev. : NC	Material	:	
First Issue : / /	Due Date	: 12/12/2008	Qty: 1 Um: Each
Previous Run : 43931	Type	: LARGE FAB ASSY	
Written By :	Checked & Approved By	: <u>SLD 08.12.05</u>	
Comment	: Est Rev:B 03.11.19 Kit redesign KJ/DS Est Rev:C 08-12-02 add QC9 and QC5 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1.0	DC	DOCUMENT CONTROL								
		<u>SLD 08.12.10</u>								
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP DSI 9288-011 CHG 002 <u>S 08/12/10</u>										
2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W								
		<u>SLD 08-12-08</u> (D)								
Comment: Qty.: 25.8300 f(s)/Unit Total : 25.8300 f(s) Material: 304/316 SS Tube 0.065" wall (M304TS0.750W.065) Batch: <u>M110D11</u>										
3.0	D23273	Spacer Bushing								
		<u>SLD 08/12/09</u>								
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>2</td> <td>D2327-3</td> <td>Spacer Bushing</td> <td><u>B39500</u></td> </tr> </table>			Qty	Part Number	Description	Batch	2	D2327-3	Spacer Bushing	<u>B39500</u>
Qty	Part Number	Description	Batch							
2	D2327-3	Spacer Bushing	<u>B39500</u>							
4.0	M304EX07516F	Expanded Metal Flat SS								
		<u>SLD 08/12/09</u>								
Comment: Qty.: 5.2500 sf(s)/Unit Total : 5.2500 sf(s) Pick: <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>5sf</td> <td>M304EX0.75-16F</td> <td>Mesh</td> <td><u>M108474</u></td> </tr> </table>			Qty	Part Number	Description	Batch	5sf	M304EX0.75-16F	Mesh	<u>M108474</u>
Qty	Part Number	Description	Batch							
5sf	M304EX0.75-16F	Mesh	<u>M108474</u>							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/12/2008 3:20:17 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET MOD KIT

Job Number: 43930

Part Number: DSI 9268011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230

2-Fabricate basket wedge assembly as per D3230

A/R SS ROD Batch: M108775

2-Deburr & Remove all Markings From Material

M 08/12/09 (1X)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 08/12/09 (1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/09 (X)

8.0

POWDER COATING

POWDER COATING



M109152



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
400 OF
9:30

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:00
400 OF
10:30

M 08/12/10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-10

(1X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/12/2008 3:20:17 PM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

11.0

AN417A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

5 AN4-17A

Bolt

M102280 3X

M109061 2X

12.0

AN960JD416

Washer



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

5 AN960JD416

Washer

M108827

13.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

5 MS21042L4

Nut (or -4)

M107499

14.0

DSI9053011

SEE DSI 9053011



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

1 DSI 9053-011

Hinge Change Kit

B22958

CHG9001

R 8/1/10 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/12/2008 3:20:17 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET MOD KIT

Job Number: 43930

Part Number: DSI 9268011

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/12/10 (40)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Dsi 9268-011

Location:

PPP Rev: A

Handwritten notes and signatures: "a/100", "08/17/10 (1)", and a signature.

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/10 (40)

Job Completion



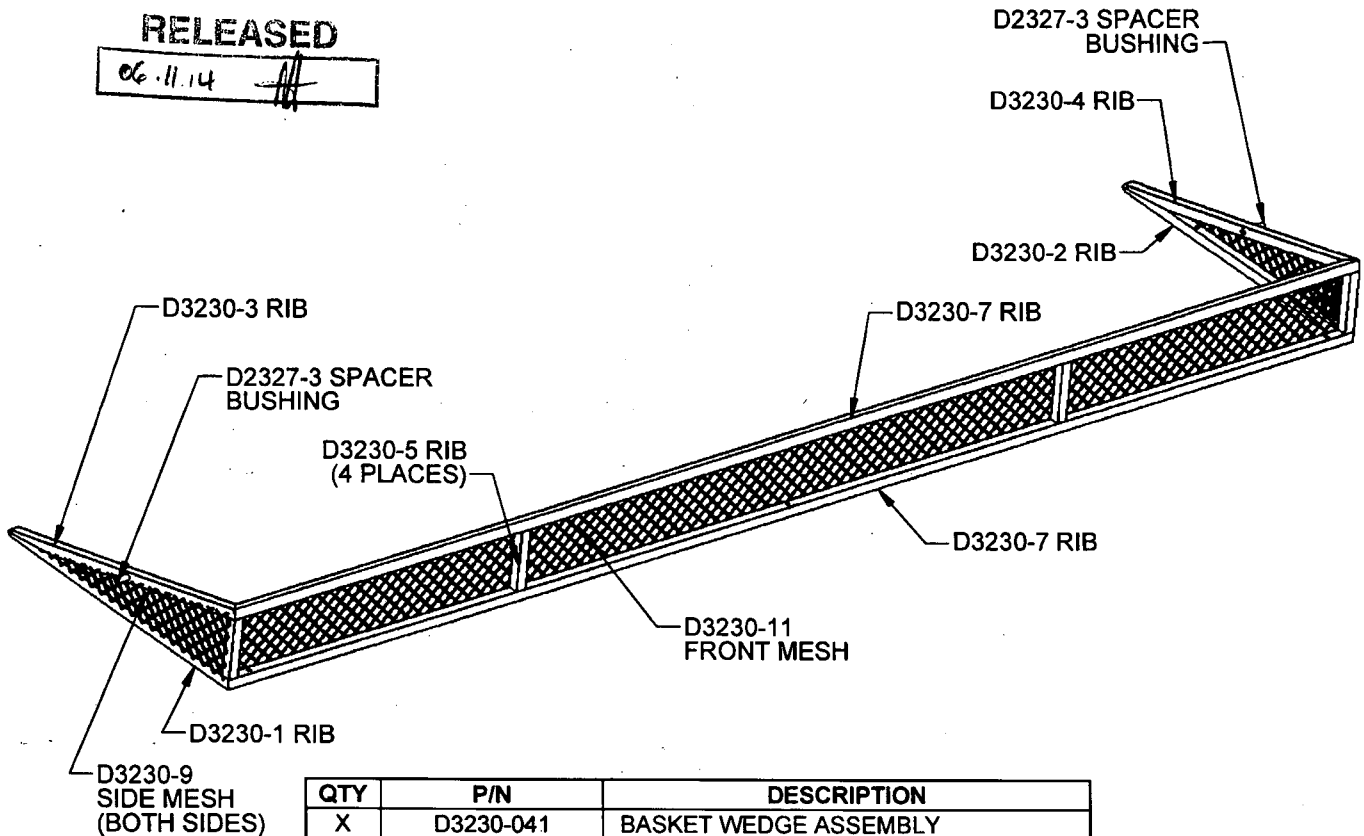
mf 08-12-10

DART

DESIGN 97	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3230	REV. B SHEET 1 OF 4
DATE 06.11.10		TITLE BASKET WEDGE ASSEMBLY	SCALE 1:32
REV	DATE	DESCRIPTION	
A	03.10.31	NEW ISSUE	
B	06.11.10	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	

RELEASED

06.11.14



QTY	P/N	DESCRIPTION
X	D3230-041	BASKET WEDGE ASSEMBLY
2	D2327-3	SPACER BUSHING
1	D3230-1	RIB
1	D3230-2	RIB
1	D3230-3	RIB
1	D3230-4	RIB
4	D3230-5	RIB
2	D3230-7	RIB
2	D3230-9	SIDE MESH
1	D3230-11	FRONT MESH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43930

NOTES:

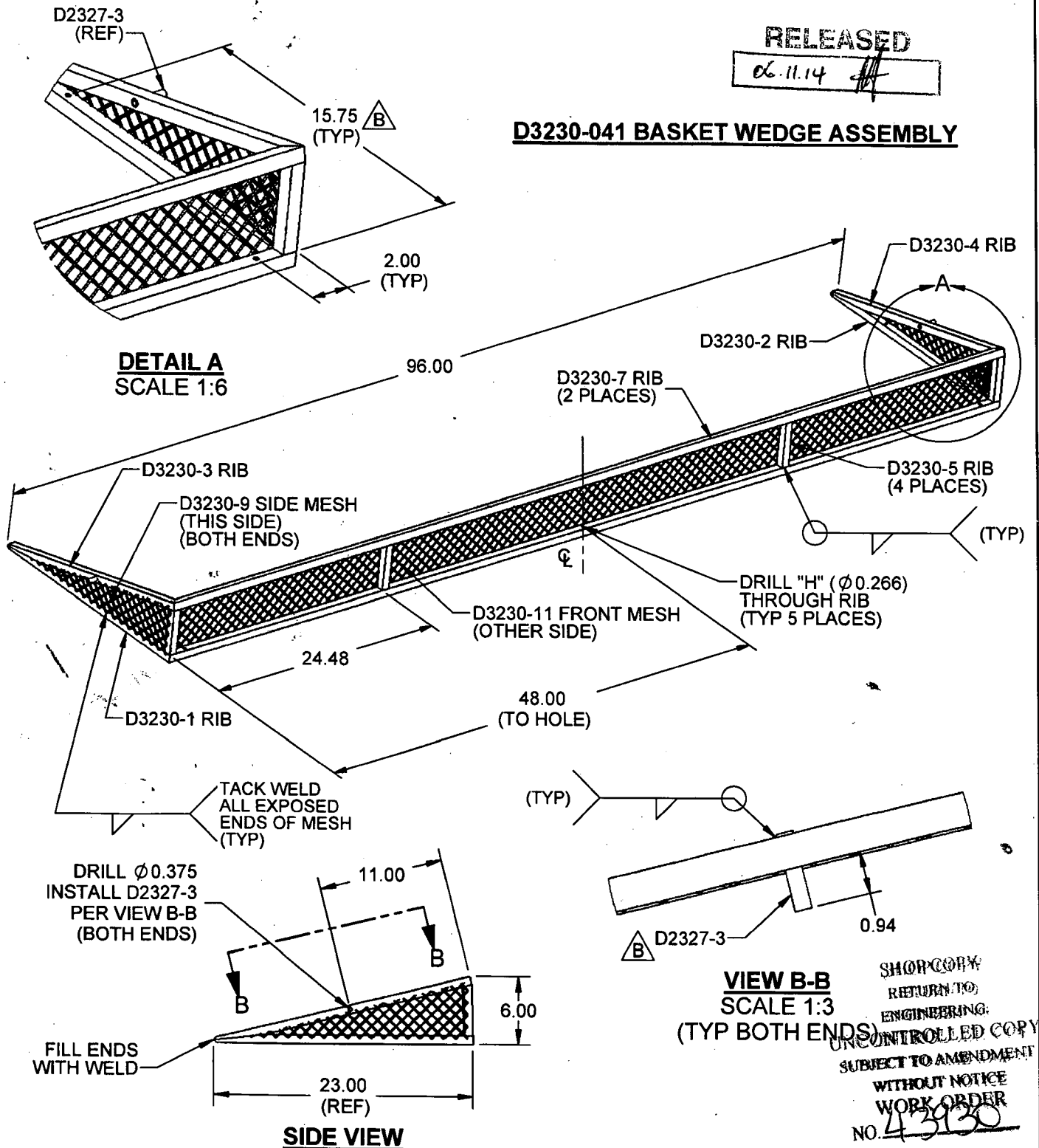
- 1) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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DART

DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3230	REV. B SHEET 2 OF 4
DATE 06.11.10		TITLE BASKET WEDGE ASSEMBLY	SCALE 1:12

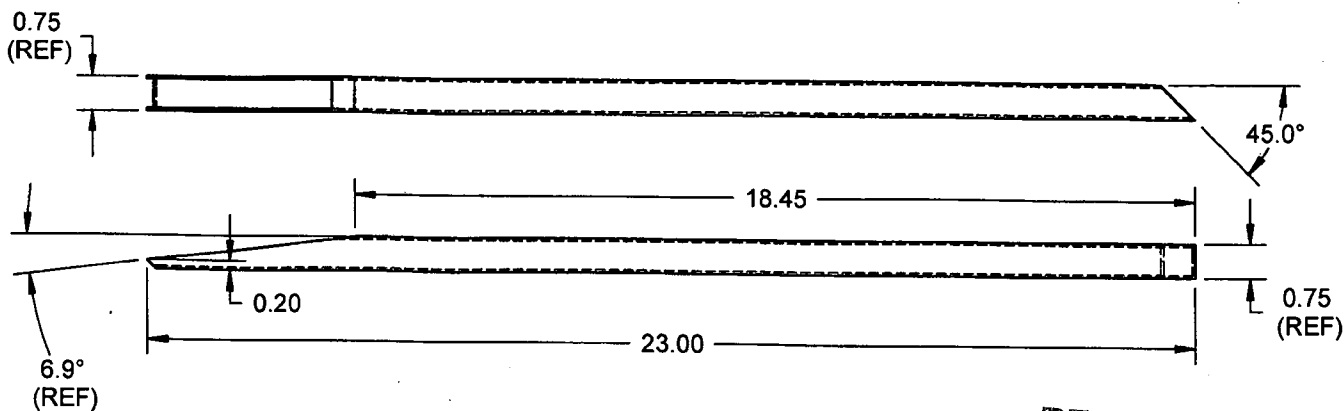
RELEASED*06.11.14***D3230-041 BASKET WEDGE ASSEMBLY**

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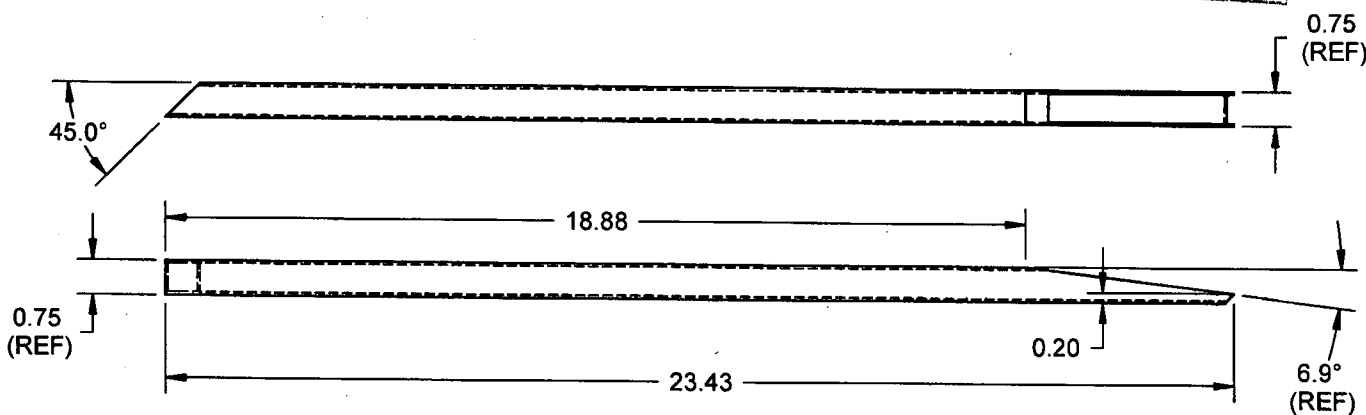


DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3230	REV. B SHEET 3 OF 4
DATE 06.11.10		TITLE BASKET WEDGE ASSEMBLY	SCALE 1:4

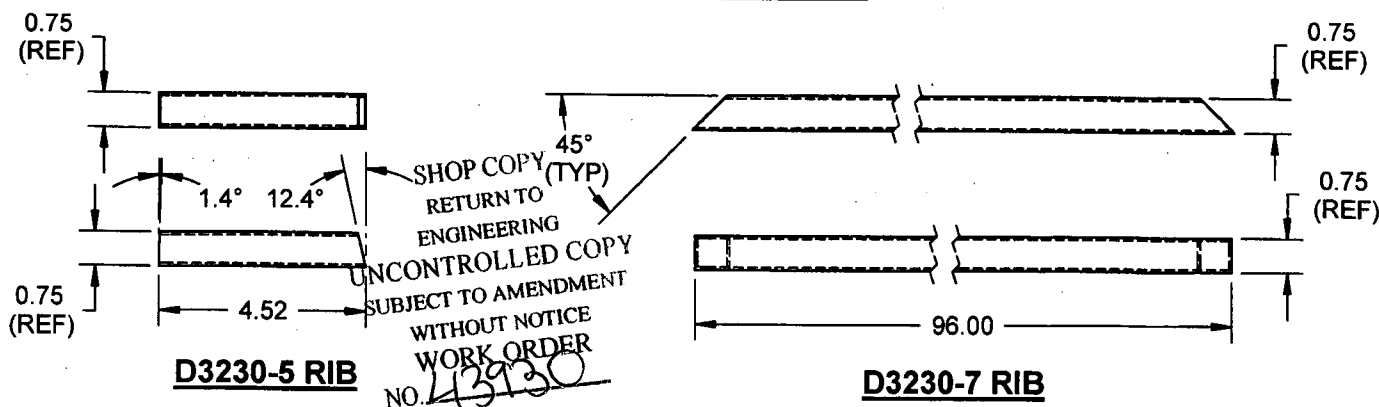


D3230-1 RIB (SHOWN)
D3230-2 RIB (OPPOSITE)

RELEASED
06.11.14 *[Signature]*



D3230-3 RIB (SHOWN)
D3230-4 RIB (OPPOSITE)



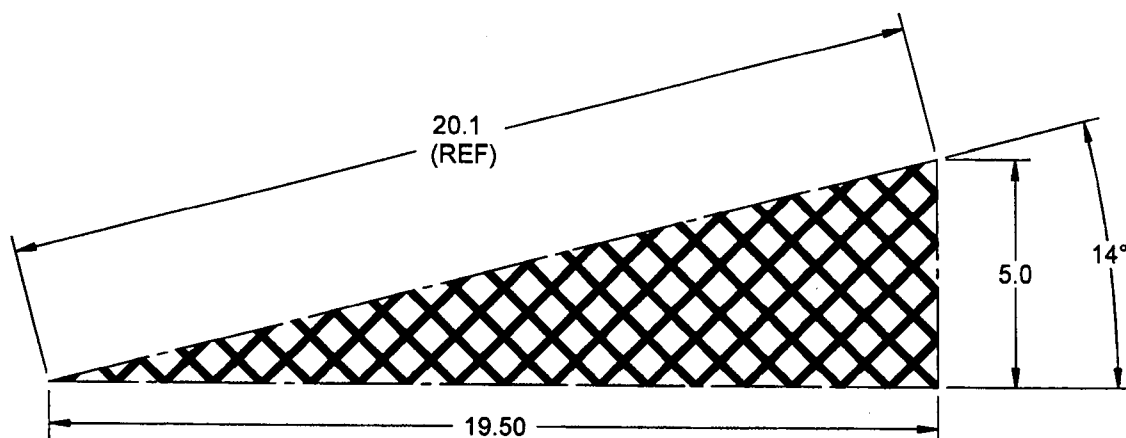
NOTE:
RIB MATERIAL: AISI 304/316 STAINLESS STEEL, 0.75 x 0.75 x 0.06 THICK SQUARE TUBING
(REF DART SPEC M304TS0.750W.060)

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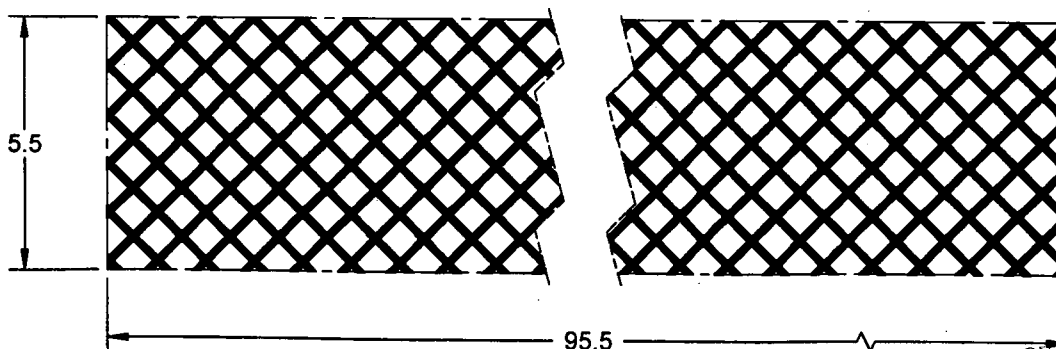
DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3230	REV. B SHEET 4 OF 4
DATE 06.11.10		TITLE BASKET WEDGE ASSEMBLY	SCALE 1:4



D3230-9 SIDE MESH

RELEASED

06.11.14 *[Signature]*



D3230-11 FRONT MESH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *4330*

NOTE:
MESH MATERIAL: 3/4 - 16F EXPANDED STAINLESS STEEL (REF DART SPEC M304EX0.75-16F)

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